

Date: Tuesday, 10/02/2009 11:09:10 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 45668		
Estimate Number	: 12451		
P.O. Number	:	Part Number	: D35001
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3500 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 45340	Material	:
Written By	:	Due Date	: 28/02/2009
Checked & Approved By	: <u>JWD 09.02.10</u>	Qty:	39 Um: Each
Comment	: Est Rev:A New Issue 06-06-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: B45033

J.F. 09/03/18

(30)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 45668 Double check by aml

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

(PTU)

(39)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / JTD

(39)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

88 09/03/23

(39)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3500-1 PAR #: N/A Fault Category: Prod / Machine / B/B NCR: Yes No DQA: P Date: 09/03/26
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: P Date: 09/03/26

NCR: <u>45668</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.19	2.0	1 shoulder scrap (1st one) bushing holes are 0.504" OD 1 flute on drill bit was chipped mat'l build up oversized the holes. R.C. broken tool.		Scrap: destroy 1 shoulder, replace tool. Replaced + B# <u>45033</u>	J.F. 09/03/23			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:10 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 45668

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMP/FL

09/03/25

(X39)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1st 24

Last 15

START TIME:

9:10

10:00

OVEN TEMPERATURE:

320°

320°

FINISH TIME:

9:40

10:30

FL

09/03/25

(39)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-25

(39)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 429

1/8 09/05/25

(39)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



MF 09-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H56003	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	
		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.504	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.177	1.178	1.178		
C	3.145	3.155		3.150	3.147	3.147	3.147		
D	1.175	1.185		1.180	1.177	1.177	1.177		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.495	0.495	0.495	0.495		
H									
I	R1.575	R1.595		1.588	1.592	1.591	1.5905		
J	0.240	0.260		0.249	0.247	0.247	0.248		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.605	3.605	3.605	3.620		
M	0.315	0.322		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.508	6.509	6.510	6.508		
P	5.990	6.010		5.991	5.999	5.999	5.999		
Q	2.820	2.830			2.825	2.825	2.825		
R	2.495	2.505			2.500	2.500	2.500		
S	2.245	2.255			2.250	2.250	2.250		
T	1.120	1.130			1.125	1.125	1.125		
U	0.540	0.560		0.548	0.547	0.546	0.5465		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.060	0.060	0.060		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.133	1.139	1.137	1.1355		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.260	0.256	0.258	0.259		
AE	1.810	1.830		1.820	1.824	1.824	1.825		
AF	0.240	0.260		0.259	0.258	0.257	0.257		
AG	0.140	0.160		0.155	0.1585	0.156	0.155		
AH	0.140	0.160		0.160	0.156	0.160	0.158		
AI	0.140	0.160		0.160	0.158	0.160	0.159		
Accept/Reject				REJECT					09/03/18

Measured by:	DA
Date:	09/03/19

Audited by:	815
Date:	09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 45663
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.486	0.486	.486	.486		
B	1.175	1.185		1.178	1.178	1.178	1.179		
C	3.145	3.155		3.147	3.147	3.147	3.147		
D	1.175	1.185		1.178	1.178	1.177	1.178		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.495	0.496	0.496	0.496		
H									
I	R1.575	R1.595		1.5905	1.5905	1.590	1.590		
J	0.240	0.260		0.2475	0.247	0.247	0.248		
K	0.490	0.510		0.497	0.498	0.498	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.320	0.320	0.320	.320		
N	0.256	0.262		0.258	0.258	0.258	.258		
O	6.500	6.520		6.510	6.509	6.509	6.510		
P	5.990	6.010		6.000	5.999	5.999	5.999		
Q	2.820	2.830		2.825	2.825	2.825	2.8245		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.547	0.548	0.546		
V	0.793	0.803		0.798	0.798	.798	0.798		
W	R.240	R.260		0.250	0.250	.250	.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.1365	1.136	1.136		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.258	0.258	0.258	0.258		
AE	1.810	1.830		1.824	1.825	1.825	1.825		
AF	0.240	0.260		0.2545	0.2555	0.2555	0.255		
AG	0.140	0.160		0.1545	0.155	0.155	0.155		
AH	0.140	0.160		0.158	0.159	0.159	0.157		
AI	0.140	0.160		0.158	0.158	0.159	0.156		
Accept/Reject									

Measured by: DJP
Date: 09/03/19

Audited by: JP
Date: 09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 45106B
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.483	0.490		.486	.486	0.486	0.486		
B	1.175	1.185		1.177	1.176	1.176	1.176		
C	3.145	3.155		3.147	3.148	3.148	3.148		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		0.375	0.375	0.375	.375		
F	0.490	0.510		0.496	0.497	0.498	0.495		
H									
I	R1.575	R1.595		1.5905	1.5895	1.591	1.589		
J	0.240	0.260		0.247	0.247	0.248	0.247		
K	0.490	0.510		0.498	0.498	.498	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.546	0.546	0.546	0.546		
V	0.793	0.803		0.798	0.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		0.060	0.060	0.060	0.060		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.136	1.136	1.136		
AB	R.490	R.510		.500	.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.253	0.255	0.253	0.253		
AE	1.810	1.830		1.825	1.825	1.825	1.825		
AF	0.240	0.260		0.2515	0.2515	0.252	0.251		
AG	0.140	0.160		0.1555	0.155	0.155	0.155		
AH	0.140	0.160		0.155	0.154	0.155	0.154		
AI	0.140	0.160		0.157	0.157	0.157	0.157		
Accept/Reject									

Measured by: DJP
Date: 09/03/20

Audited by: SP
Date: 09/03/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 457608
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.177	1.177	1.177	1.177		
C	3.145	3.155		3.148	3.148	3.148	3.148		
D	1.175	1.185		1.177	1.178	1.178	1.177		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.496	0.4965	0.497	0.497		
H									
I	R1.575	R1.595		1.590	1.5895	1.591	1.5905		
J	0.240	0.260		0.248	0.248	0.249	0.249		
K	0.490	0.510		0.497	0.4975	0.497	0.497		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.546	0.547	0.547	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.060	0.060	0.060	0.060		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.135	1.136	1.1355		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.254	0.253	0.253	0.254		
AE	1.810	1.830		1.825	1.825	1.825	1.825		
AF	0.240	0.260		0.251	0.251	0.251	0.250		
AG	0.140	0.160		0.155	0.155	0.155	0.155		
AH	0.140	0.160		0.156	0.156	0.155	0.154		
AI	0.140	0.160		0.158	0.157	0.158	0.158		
Accept/Reject									

Measured by: DJP
Date: 09/03/20

Audited by: JB
Date: 09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 45200
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.177	1.177	1.179	1.179		
C	3.145	3.155		3.148	3.148	3.149	3.149		
D	1.175	1.185		1.177	1.178	1.179	1.179		
E	0.365	0.385		0.375	0.375	0.376	0.376		
F	0.490	0.510		0.500	0.499	0.500	0.496		
H									
I	R1.575	R1.595		R1.591	R1.590	R1.591	R1.589		
J	0.240	0.260		0.250	0.250	0.250	0.248		
K	0.490	0.510		0.499	0.500	0.500	0.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.258	0.258	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.255	2.254		
T	1.120	1.130		1.125	1.125	1.128	1.128		
U	0.540	0.560		0.548	0.550	0.549	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	R.250	R.250		
X	0.040	0.060		0.060	0.060	0.060	0.060		
Y	0.100	0.120		0.103	0.103	0.103	0.103		
AA	R1.125	R1.145		1.137	1.135	1.137	R1.134		
AB	R.490	R.510		0.500	0.500	R.500	R.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.255	0.252	0.252	0.252		
AE	1.810	1.830		1.824	1.824	1.823	1.823		
AF	0.240	0.260		0.250	0.251	0.253	0.250		
AG	0.140	0.160		0.156	0.155	0.156	0.154		
AH	0.140	0.160		0.155	0.155	0.155	0.155		
AI	0.140	0.160		0.159	0.156	0.156	0.156		
Accept/Reject									

Measured by: DJP / J.F.
Date: 09/03/20

Audited by: [Signature]
Date: 09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	451008
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.486"	0.486"	0.486"	0.486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.149"	3.149"	3.149"	3.149"		
D	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
E	0.365	0.385		0.376"	0.376"	0.376"	0.376"		
F	0.490	0.510		0.498"	0.495"	0.496"	0.498"		
H									
I	R1.575	R1.595		R1.584"	R1.588"	R1.589"	R1.589"		
J	0.240	0.260		0.249"	0.248"	0.248"	0.248"		
K	0.490	0.510		0.500"	0.500"	0.500"	0.499"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.322		0.320"	0.320"	0.320"	0.320"		
N	0.256	0.262		0.259"	0.259"	0.259"	0.259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.510"		
P	5.990	6.010		6.002"	6.002"	6.002"	6.002"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
S	2.245	2.255		2.254"	2.254"	2.254"	2.254"		
T	1.120	1.130		1.127"	1.127"	1.127"	1.127"		
U	0.540	0.560		0.550"	0.549"	0.550"	0.550"		
V	0.793	0.803		0.798"	0.798"	0.798"	0.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		0.055"	0.055"	0.055"	0.055"		
Y	0.100	0.120		0.105"	0.105"	0.105"	0.105"		
AA	R1.125	R1.145		R1.135"	R1.134"	R1.135"	R1.134"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		0.635"	0.635"	0.635"	0.635"		
AD	0.240	0.260		0.253"	0.252"	0.252"	0.252"		
AE	1.810	1.830		1.820"	1.820"	1.820"	1.820"		
AF	0.240	0.260		0.252"	0.251"	0.252"	0.252"		
AG	0.140	0.160		0.155"	0.154"	0.155"	0.154"		
AH	0.140	0.160		0.150"	0.150"	0.150"	0.150"		
AI	0.140	0.160		0.155"	0.153"	0.154"	0.155"		
Accept/Reject									

Measured by:	JF
Date:	09/03/21

Audited by:	JP
Date:	09/23/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	456603
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
A	0.483	0.490		Ø .486"	Ø .486"	Ø .486"	Ø .486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.144"	3.149"	3.144"	3.149"		
D	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
E	0.365	0.385		.376"	.376"	.376"	.376"		
F	0.490	0.510		.497"	.497"	.497"	.497"		
H									
I	R1.575	R1.595		R1.588"	R1.588"	R1.588"	R1.590"		
J	0.240	0.260		.249"	.249"	.250"	.250"		
K	0.490	0.510		.501"	.501"	.500"	.500"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.322		Ø .320"	Ø .320"	Ø .320"	Ø .320"		
N	0.256	0.262		Ø .259"	Ø .259"	Ø .259"	Ø .259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.510"		
P	5.990	6.010		6.002"	6.002"	6.002"	6.002"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
S	2.245	2.255		2.254"	2.254"	2.254"	2.254"		
T	1.120	1.130		1.127"	1.127"	1.127"	1.127"		
U	0.540	0.560		.550"	.550"	.550"	.550"		
V	0.793	0.803		.798"	.798"	.798"	.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.055"	.055"	.055"	.055"		
Y	0.100	0.120		.105"	.105"	.105"	.105"		
AA	R1.125	R1.145		R1.134"	R1.134"	R1.134"	R1.136"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.635"	.625"	.625"	.625"		
AD	0.240	0.260		.252"	.253"	.252"	.251"		
AE	1.810	1.830		1.820"	1.820"	1.820"	1.820"		
AF	0.240	0.260		.252"	.251"	.251"	.253"		
AG	0.140	0.160		.154"	.154"	.153"	.156"		
AH	0.140	0.160		.150"	.149"	.151"	.149"		
AI	0.140	0.160		.155"	.154"	.155"	.154"		
Accept/Reject									

Measured by:	J.F.
Date:	09/03/22

Audited by:	SP
Date:	09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 457668
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	29	30	31	32	By	Date
A	0.483	0.490		0.486"	0.486"	0.486"	0.486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.149"	3.149"	3.149"	3.149"		
D	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
E	0.365	0.385		0.376"	0.376"	0.376"	0.376"		
F	0.490	0.510		0.499"	0.500"	0.499"	0.497"		
H									
I	R1.575	R1.595		R1.588"	R1.588"	R1.589"	R1.587"		
J	0.240	0.260		0.249"	0.250"	0.249"	0.249"		
K	0.490	0.510		0.500"	0.500"	0.501"	0.501"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.322		0.320"	0.320"	0.320"	0.320"		
N	0.256	0.262		0.259"	0.259"	0.259"	0.259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.510"		
P	5.990	6.010		6.002"	6.002"	6.002"	6.002"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
S	2.245	2.255		2.254"	2.254"	2.254"	2.254"		
T	1.120	1.130		1.127"	1.127"	1.127"	1.127"		
U	0.540	0.560		0.550"	0.550"	0.549"	0.550"		
V	0.793	0.803		0.798"	0.798"	0.798"	0.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		0.055"	0.055"	0.055"	0.055"		
Y	0.100	0.120		0.105"	0.105"	0.105"	0.105"		
AA	R1.125	R1.145		R1.134"	R1.134"	R1.134"	R1.133"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		0.625"	0.625"	0.625"	0.625"		
AD	0.240	0.260		0.252"	0.252"	0.252"	0.253"		
AE	1.810	1.830		1.820"	1.820"	1.820"	1.820"		
AF	0.240	0.260		0.251"	0.251"	0.252"	0.251"		
AG	0.140	0.160		0.154"	0.153"	0.154"	0.154"		
AH	0.140	0.160		0.150"	0.151"	0.150"	0.149"		
AI	0.140	0.160		0.155"	0.154"	0.155"	0.154"		
Accept/Reject									

Measured by: J.F.
Date: 09/23/22

Audited by: [Signature]
Date: 09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: <i>456003</i>
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

2.335

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	33	34	35	36		
A	0.483	0.490		0.486"	0.486"	0.486"	0.486"		
B	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
C	3.145	3.155		3.149"	3.149"	3.149"	3.149"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		0.377"	0.377"	0.377"	0.377"		
F	0.490	0.510		0.498"	0.497"	0.498"	0.498"		
H									
I	R1.575	R1.595		R1.589"	R1.587"	R1.589"	R1.589"		
J	0.240	0.260		0.252"	0.249"	0.249"	0.249"		
K	0.490	0.510		0.500"	0.500"	0.501"	0.500"		
L	3.590	3.650		3.650"	3.650"	3.650"	3.650"		
M	0.315	0.322		0.321"	0.321"	0.321"	0.321"		
N	0.256	0.262		0.259"	0.259"	0.259"	0.259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.510"		
* P	5.990	6.010		5.998"	5.999"	5.998"	5.998"		
* Q	2.820	2.830		2.826"	2.826"	2.826"	2.826"		
* R	2.495	2.505		2.504"	2.504"	2.504"	2.504"		
S	2.245	2.255		2.253"	2.253"	2.253"	2.253"		
T	1.120	1.130		1.127"	1.127"	1.127"	1.127"		
U	0.540	0.560		0.550"	0.549"	0.549"	0.548"		
* V	0.793	0.803		0.803"	0.803"	0.803"	0.803"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		0.055"	0.055"	0.055"	0.055"		
Y	0.100	0.120		0.105"	0.105"	0.105"	0.105"		
AA	R1.125	R1.145		R1.134"	R1.133"	R1.134"	R1.136"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		0.628"	0.628"	0.628"	0.628"		
AD	0.240	0.260		0.252"	0.252"	0.253"	0.253"		
* AE	1.810	1.830		1.818"	1.819"	1.819"	1.819"		
AF	0.240	0.260		0.252"	0.252"	0.252"	0.253"		
AG	0.140	0.160		0.154"	0.154"	0.155"	0.156"		
AH	0.140	0.160		0.150"	0.151"	0.150"	0.150"		
AI	0.140	0.160		0.156"	0.156"	0.156"	0.156"		
Accept/Reject									

Measured by:	<i>J.F.</i>
Date:	<i>09/03/23</i>

Audited by:	<i>[Signature]</i>
Date:	<i>09/03/23</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<i>[Signature]</i>

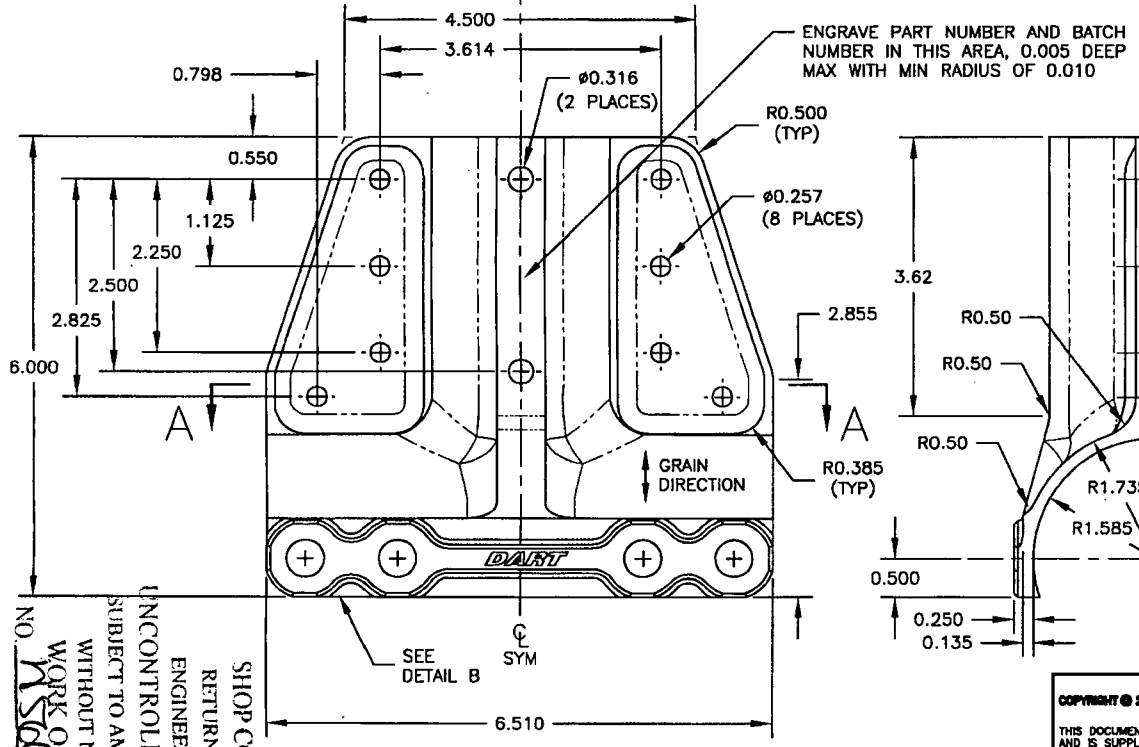
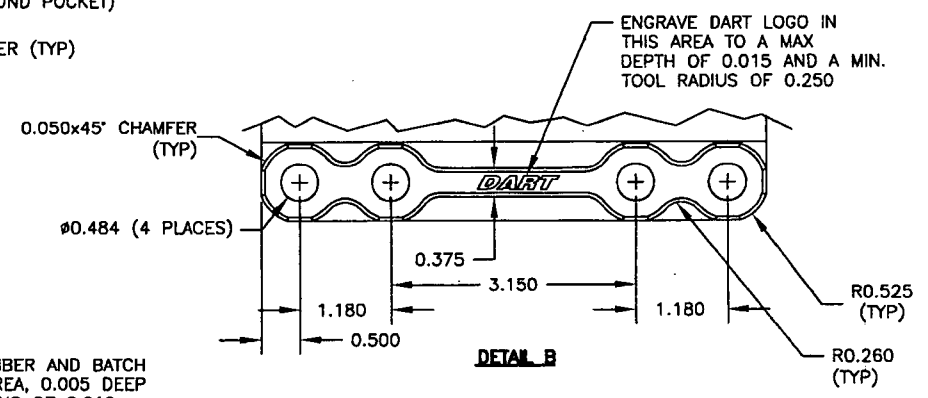
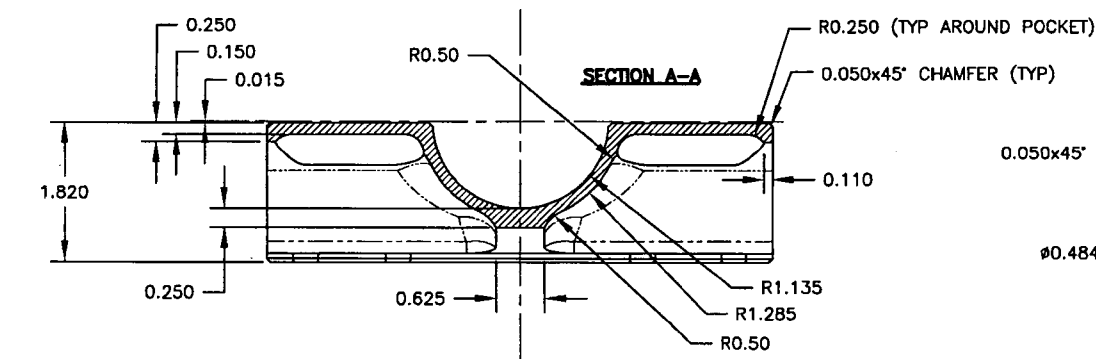
DART AEROSPACE LTD		Work Order: 45668
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				37 A	38 X	39 X	40 A		
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.149	3.149	3.149	3.149		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.376	0.376	0.377	0.377		
F	0.490	0.510		0.500	0.498	0.500	0.500		
H									
I	R1.575	R1.595		R1.588	R1.587	R1.588	R1.589		
J	0.240	0.260		0.250	0.248	0.251	0.251		
K	0.490	0.510		0.500	0.500	0.501	0.501		
L	3.590	3.650		3.650	3.650	3.650	3.650		
M	0.315	0.322		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.259	0.259	0.259	0.259		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.998	6.000	5.999		
Q	2.820	2.830		2.826	2.826	2.826	2.826		
R	2.495	2.505		2.504	2.504	2.504	2.504		
S	2.245	2.255		2.253	2.253	2.253	2.253		
T	1.120	1.130		1.127	1.127	1.127	1.127		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.803	0.803	0.803	0.803		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		R1.134	R1.134	R1.134	R1.134		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		0.628	0.628	0.628	0.628		
AD	0.240	0.260		0.253	0.252	0.253	0.253		
AE	1.810	1.830		1.818	1.819	1.819	1.818		
AF	0.240	0.260		0.251	0.251	0.252	0.252		
AG	0.140	0.160		0.154	0.154	0.154	0.154		
AH	0.140	0.160		0.149	0.149	0.144	0.149		
AI	0.140	0.160		0.156	0.156	0.155	0.155		
Accept/Reject									

Measured by: J.F.
Date: 09/03/23

Audited by: [Signature]
Date: 09/03/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	9P	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DRAWING NO.	D3500	REV. C
		SHEET 1 OF 1
		SCALE
		23

DART DART AEROSPACE LTD.
MISSISSAUGA, ONTARIO, CANADA